

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007752**Date Inspected:** 05-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2-

This QA inspector performed Ultrasonic Testing (UT) of approximately 50% of the area previously tested and accepted by ZPMC Quality Control personnel. Testing was performed on OBG Segment 1AAW base metal repair areas adjacent to pipe penetrations for locations A00 and A41.

Bay 6-

QA Inspector observed the following work in progress: SMAW welding of weld joints 012 and 013 located on West Tower Lift 3 Double diaphragm, WSD1-DPSA4-10 B/B. ZPMC welders were identified as 068924 and 037932. ZPMC QC was identified as Liu Yang. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3312-TC-P5.

Bay 11-

QA Inspector observed the following work in progress: FCAW welding of weld joints ESTL3-4 J/K- 043 and ESTL3-4 I/K-046 located on East Tower lift 3. ZPMC welders were identified as 069043 and 070212. ZPMC QC is identified as Zhang Zhi Neng. The welding appeared to be in conformance with welding procedure specification,

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WPS-B-T-2133.

SAW welding of weld joints 21B and 23B located on West Tower Lift 4 Skin Plate A WSD1-FASA4-A/F. ZPMC welder was identified as 042195. ZPMC QC was identified as Zhang Zhi Neng. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4221-B-U3C-S-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
